

Work Order ID 73568

Friday, September 02, 2011 2:20:31 PM



Rush

Page 1

Item ID: D2648-3

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 9/2/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *11-09-02* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2648

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2648

*****CUT WITH FILE D2648-1*****

Dwg Rev: *D*

Prog Rev: *D*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 11-9-6

(2)

B 11-9-6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

S 11/09/07

counter
(721)

130



Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary

0.00

0.00

h 1/15

140



Brake NC

Brake NC

NC BRAKE

Memo

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.
2-Identify as D2648-3

0.00

0.00

S 11/09/07

21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 73568

Friday, September 02, 2011 2:20:31 PM



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Item ID: D2648-3

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Revision ID:

Stop



Item Name: Wearpad

Start Date: 9/2/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

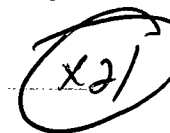


Large Fab

Weld per dwg A/R Hardcoat steel Batch: M117964 0.00
Large Fab

Memo

0.00

EL H-9-7

Large Fab

1-Weld as per Dwg D2648 using Jig DT 8210
2-Remove any weld that penetrated through Wearpad if necessary

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds 0.00

Memo

0.00

8.10964

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

8.10964counted
(X21)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 73568

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Item ID: D2648-3

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Start Date: 9/2/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:45
320 OF
2:15

21X of m-k 11/09/07

190

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

21 of M 11/09/07

200

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

0.00

changes place
237

11/9/07 S/E

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 73568

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Item ID: D2648-3

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Revision ID:

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Item Name: Wearpad

Start Date: 9/2/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/8 2J

MF
11-09-08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Friday, September 02, 2011 2:20:27 PM

Page 1

Work Order ID: 73568

Parent Item: D2648-3

Parent Item Name: Wearpad





Start Date: 9/2/2011

Required Date: 9/8/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: E02.09.18 Re-format; Incorporated D2648-1 KJ/RF
IPP Rev:F Now on Waterjet 06-08-14 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|--------------|---------------|----------------|--------|
| M1010S16GA  1010/1025 sheet 16GA | | Purchased | No | | | 100 | sf | 65.3000 | 0.075 | 0.473684 | 1.6 | | |
| | | | | | | | | |  | | B11-9-6 | | |

Location

Loc Qty

Loc Code

MAT019

65.3

116791

32.5

117500

32.8

116791

(21)

| W/O: | | WORK ORDER CHANGES | | | | | |
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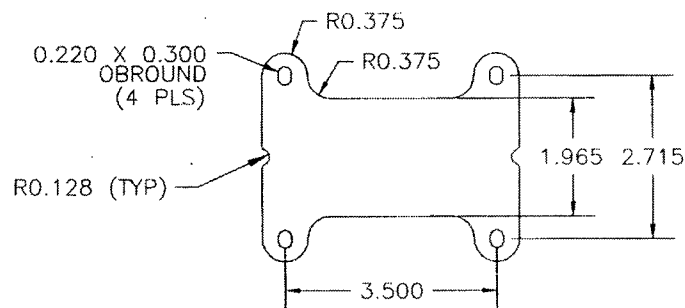
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

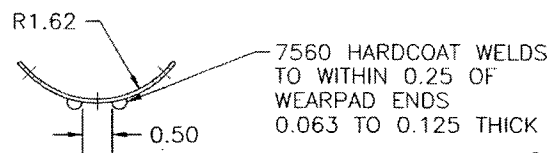
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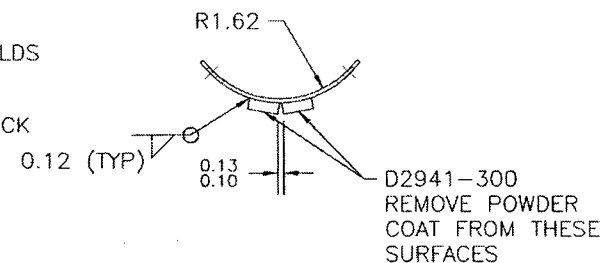
D2648-1 FLAT PATTERN



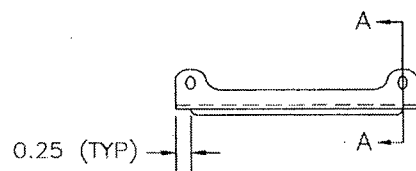
SECTION A-A



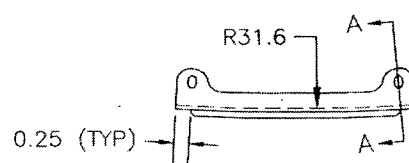
SECTION B-B



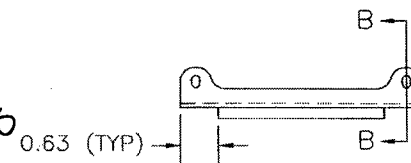
D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

#73568

RELEASED
1997.12.20 DS



| | | |
|----------|----------|--|
| D | 99.11.17 | ADDED D2648-7 |
| C | 97.06.26 | R31.6 WAS R19.6 |
| B | 97.05.30 | ENLARGE OBOUND, 0.375 WAS 0.250 |
| A | 97.03.25 | NEW ISSUE |
| DESIGN | DRAWN BY | DART DART AEROSPACE USA, INC. BOLLEVILLE, WA |
| CHECKED | APPROVED | DRAWING NO. D2648 SHEET 1 OF 1 |
| DATE | TITLE | WEARPAD SCALE 1:2 |
| 99.11.17 | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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